

Work Order ID 79984

Wednesday, February 08, 2012 2:53:56 PM

79984

Ship Feb 16 Page 1

Item ID: D2946-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step, 350

Start Date: 2/8/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/16/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *12-02-08* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2946

Rev B

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

12-02-09

2

2-Deburr

Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

12-02-09

2x

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79984

Page 2

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Date:

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QC:

Date:

SPC (Y/N):

Date:

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Sequence ID/
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Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Large Fab

Large Fab

Large Fab

Memo

1-Deburr and Bevel ends for welding

2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946
A/R Aluminum Rod 119785

3-Grind End Cap welds flush

12.02.09

2

Ø

Ac 12/02/13

140

140

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

2

Ø

BE 12-02-13

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5 12/02/14

(x2)

Work Order ID 79984***79984***

Page 3

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

Ac 12/02/14

(x2)

Ø

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

Ac 12.02.14

2

Ø

180

Large Fab

0.00

180

Large Fab

Memo

0.00

Large Fab

Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush.

A/R AL ROD BATCH: 119785

Ac 12.02.14

2

Ø

Work Order ID 79984***79984***

Page 4

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

190

QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

210

HandFinish

Memo

0.00

Hand Finishing

2 BL 12-2-14

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79984

Page 5

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

220

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

230

Wing Walk as per dwg QSI005 4.4 Batch 119094, 0.00

230

HandFinish

Hand Finishing

Memo

0.00

240

QC3- Inspect Part Finish

0.00

240

QC

Quality Control

Memo

0.00

2X4 M-L 12/02/15

2 BL 12.2.15.

2 p M 12/02/15

1119480

9-00
320 OF
9-30

Work Order ID 79984

79984

Page 6

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Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

270

Identify as per dwg & Stock Location: _____

0.00

270

Packaging

Packaging

Memo

SHIP

0.00

Packaging

4/2/15 (2)

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

12/2/15
ME
12-02-15

Picklist Print

Wednesday, February 08, 2012 2:53:55 P

Page 1

Work Order ID: 79984

Parent Item: D2946-041

Parent Item Name: Step, 350

Start Date: 2/8/2012

Required Date: 2/16/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-02-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No				Each	156.7700		1.04		12.02.09	

Location Loc Qty Loc Code

HALL 16.37
46910 2
64409 6
66970 7.7
68293 0.25
72131 0.42
WA013 140.4
75781 10.4
77612 130

D2734

Step End Plate

Manufactured No

Each 97.0000

4

Location Loc Qty Loc Code

WA 97
76985 97

D2944

Step Mounting Plate

Manufactured No

Each 8.0000

4

Location Loc Qty Loc Code

WA018 8
73427 8



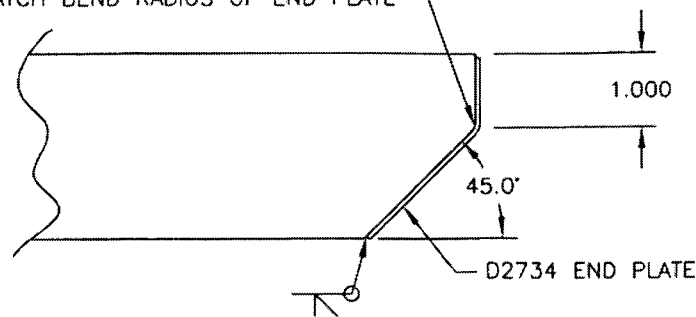
D2946 STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2946	Step Assembly	X
D2622-63	STEP EXTRUSION*	1
D2734	END PLATE	2
D2944	STEP MOUNTING PLATE	2

*cut per drawing

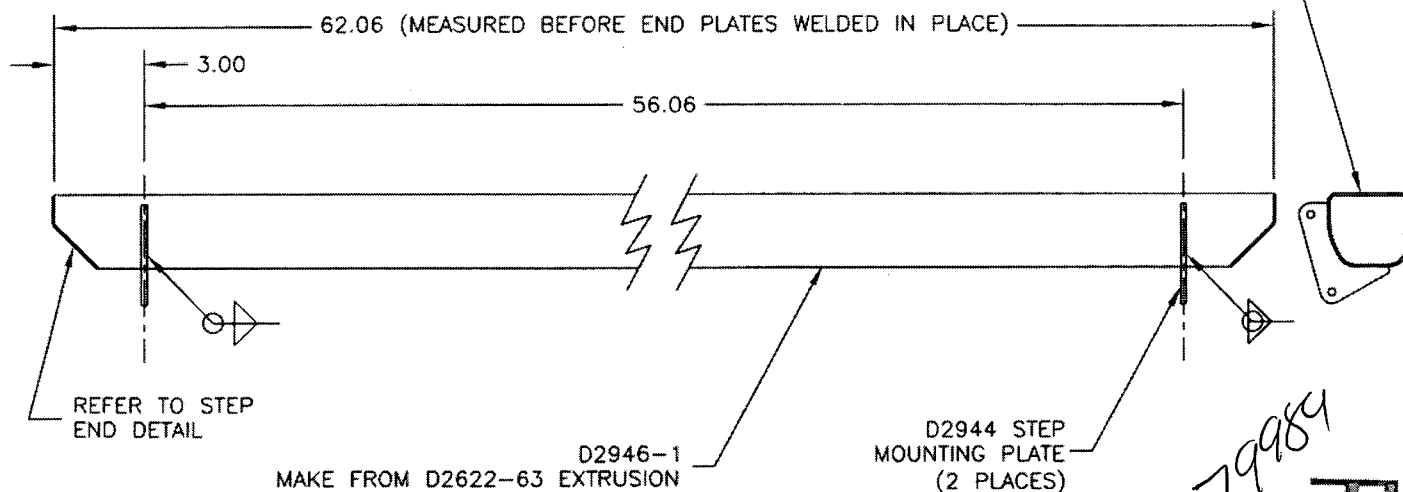
NOTE: ALL WELDS SHALL BE
100% VISUALLY
INSPECTED BY A
QUALIFIED INSPECTOR
PER DART QSI 004

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS



D2946-041 STEP ASSEMBLY

D2946 STEP ASSEMBLY

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D2946
DATE	TITLE	SHEET 1 OF 1
05.11.14	STEP ASSEMBLY	SCALE
A	99.12.13	1:6
B	05.11.14	UPDATE FINISHING NOTE

RELEASED
05.11.14